

Work Order ID 50410

September 28, 2009 10:46:50 AM



Page 1

Item ID: D3163-042
Revision ID: D
Item Name: Cover Assembly

Accept



Setup Start



Stop



Start Date: 7/15/09 Start Qty: 2.00
Required Date: 7/15/09 Req'd Qty: 2.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start
Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
|----------|--------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
|----------|--------------|

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Rivet D3163-3 to D3163-1 Ensure holes line up

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Inspect bonding of D3163-1/-3

120

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 2:00pm FINISH TIME: 2:30pm OVEN TEMPERATURE: 320°F

9/28/09 (2)

(42)

4

(42)

4

2/50/10/01

2/50/10/01

| W/O: 50410 | | WORK ORDER CHANGES | | | | | |
|------------|------|--|----|----------|-----|-------------------------------------|--------------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 09/10/02 | 100 | Replace rivet MS 20426 AD 3-5 for rivet MS 20426 AD 3-4 M <u>1221</u> -5 is too long. <i>f</i> | S | 09/10/02 | 4 | <i>[Signature]</i> 09/10/02 | <i>[Signature]</i> 09/10/02 |
| | | | | | | | |

Part No: D3163-042 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

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Item ID: D3163-042
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Accept



Setup Start



Stop



Start Date: 7/15/09 Start Qty: 2.00
Required Date: 7/15/09 Req'd Qty: 2.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start
Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

m-p 09/10/01 (2)

140

Small Fab

0.00



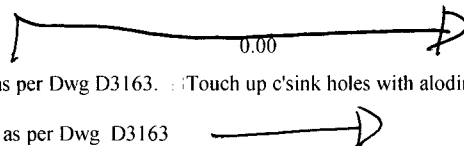
Small Fab

Memo

0.00

Small Fab

C'sink D3163-3 as per Dwg D3163. Touch up c'sink holes with alodine.
Install Nut Plates as per Dwg D3163



EP 09/10/01 (2)
EP 09/10/02 (2)

PTO

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> 8/10/02

(42) f

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Item ID: D3163-042
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Accept



Setup Start



Stop



Start Date: 7/15/09 Start Qty: 2.00
Required Date: 7/15/09 Req'd Qty: 2.00



Cust Item ID:
Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

9/10/02

2081

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/01/08
mf 09/10-03

Picklist Print

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Work Order ID: 50410

Parent Item: D3163-042RevD

Parent Item Name: Cover Assembly



Comments:

Start Date: 7/15/09

Required Date: 7/15/09

Start Qty: 2.00

Required Qty: 2.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3163-1RevD | | Manufactured | No | | | 100 | Each | 0.0000 | 2.0000 | | | |
|  | | | | | | | | | | | | |
| Plate | | | | | | | | | | | | |
| D3163-3RevD | | Manufactured | No | | | 100 | Each | 4.0000 | 2.0000 | | | |
|  | | | | | | | | | | | | |
| Plate | | | | | | | | | | | | |

B50398

EP 09/10/01

EP 09/10/01

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

50334

4

4

16

2

MS20426AD3-4

Purchased

No

140

Each

8,221.000 8.0000



RIVET



EP 09/10/01

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

104374

110398

8221

4221

4000

8

MS21059L08

Purchased

No

100

Each

237.0000 4.0000



Nut



EP 09/10/01

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

112314

12706

237

200

37

4

MS20426AD3-5

MS 09/10/02 Rivet

Qty 4

Batch: 14479

EP 09/10/02

RECEIVED
JAN 29 1964



(D3163-2 PLATE OPPOSITE)

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (REF. DART SPEC. M2024T3S.032) OR
6061-T6 (QQ-A-250/11) 0.032 THICK (REF. DART SPEC. M6061T6S.032)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 0.250

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063) OR
6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

GENERAL NOTES:

- 1) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3 AFTER ASSEMBLY OF D3163-3 PLATE BUT BEFORE INSTALLATION OF MS21059L08 NUTPLATES
- 2) BREAK SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY TOP ASSEMBLY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

| | | | | |
|----------------------|-----------------------|--|--------------|--------|
| DESIGN RF | DRAWN BY CB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | REV. D |
| CHECKED <i>EH</i> | APPROVED <i>EH</i> | DRAWING NO. D3163 | SHEET 1 OF 1 | |
| DATE 06.06.26 | | TITLE PLATE | SCALE 1:6 | |
| A | 02.04.26 | NEW ISSUE | | |
| B | 04.10.06 | 7.33 WAS 7.20; REMOVE PERIMETER HOLES | | |
| C | 05.11.22 | Ø1.050 WAS Ø1.000 | | |
| D | 06.06.26 | ADD 4 RIVETS; REMOVE ADHESIVE | | |

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